304 .750

Work Order ID 85788

June-15-12 10:47:12 AM

ASAP

85788

Item ID: D3953-3 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Gas Spring Stud, Lid

Start Date: 15/06/2012 **Start Qty:** 30.00 *30*

Required Date: 22/06/2012 **Req'd Qty:** 30.00 *30*

Cust Item ID:

Customer:

Reference:

Approvals: **Process Plan:** MLJ **Date:** 12/06/15 **Tooling:** **Date:** **Run Start** *NR1*

QC: **Date:** **SPC (Y/N):** **Date:** **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D3953	C								
100		0.00				30	0		
100									
Doosan	**Memo**	0.00							
Doosan Lathe	Turn as per folio FA852 & DWG FOLIO REV: WK DWG REV: C DEBURR								
110	QC2- Inspect parts off machine FAI/FAIB	0.00				30	0		
110									
QC	**Memo**	0.00							
Quality Control									

SA 12/6/24

SA 12/6/24

Work Order ID 85788

June-15-12 10:47:12 AM

85788

Item ID: D3953-3 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Gas Spring Stud, Lid

Start Date: 15/06/2012 **Start Qty:** 30.00 *30*

Required Date: 22/06/2012 **Req'd Qty:** 30.00 *30*

Cust Item ID:

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00	ok 12/06/24			30	0		
120									
QC	**Memo**	0.00							
Quality Control									
130	Identify as per dwg & Stock Location: ST 75	0.00							
130						30x			SP 12-6-25
Packaging	**Memo**	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									12/6/25 MF 12-06-25
QC	**Memo**	0.00							
Quality Control									

Picklist Print

June-15-12 10:47:15 AM

Work Order ID: 85788

85788

Parent Item: D3953-3

D3953-3

Parent Item Name: Gas Spring Stud, Lid

Start Date: 15/06/2012 **Required Date:** 22/06/2012

Start Qty: 30.00 **Required Qty:** 30.00

Comments: IPP RevA: New issue DD verified by:EC
per dwg revC DD 10.03.02 verified by:EC IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304RO.750		Purchased	No			100	f	38.6170	0.125	3.947368			
M304RO.750									**	4	12/6/24		
304 SS Roundbar .750													

Location	Loc Qty	Loc Code	
MAT028	30.4		
116501	1.746		
116623	0.854		
121282	27.8		4 ft
MAT029	8.217		
117481	1.717		
118509	6.2		
120124	0.3		

2

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Other ☐
- Engineering ☐
- Quality ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Offset/Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unauthorized	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending Passes Below Min
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimp at Bending
- ☐ Inspection Strip in Tube
- ☐ Other
- ☐ Positioned Wrong
- ☐ Ripples on Inner Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

Hardware

- ☐ Breaking
- ☐ Missing
- ☐ Size/Length
- ☐ Spinning
- ☐ Threading
- ☐ Wrong

Drill Holes

- ☐ Misaligned
- ☐ Ovalized
- ☐ Over/Undersized
- ☐ Too Many

General

- ☐ Burrs
- ☐ Contamination
- ☐ Cut Too Short
- ☐ Documentation/Data
- ☐ Finish
- ☐ Inspection Incomplete
- ☐ Inspection Unqualified
- ☐ Instructions Incomplete/Unclear
- ☐ Jigs/Fixtures/Tooling
- ☐ Kit Incorrect
- ☐ Kit Missing
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Off-Set
- ☐ Orientation Misread
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Over/Under tolerance
- ☐ Part Lost
- ☐ Part Moved
- ☐ Raw Material
- ☐ Set-up
- ☐ Supplier
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

DART AEROSPACE LTD	Work Order:	85782
Description: Gas Spring Stud, Lid	Part Number:	D3953-3
Inspection Dwg: D3953 **Rev:** C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

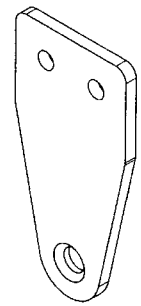
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.75	+/-0.030	.75	✓		SA-2	Ver
0.56	+/-0.010	.56	✓			
0.281	+/-0.010	.281	✓			
1/4-28 UNF-2A	N/A		✓			
Major Ø	Max = 0.2490 Min = 0.2425	.246	✓		SA-5	Mic
M.O.W.	Max = 0.26687 Min = 0.26357	.265	✓		SA-5	Mic
Ø0.098	+0.004/-0.001	.099	✓			
Ø0.250	+/-0.010	.245	✓			
0.170	+/-0.010	.169	✓			
0.330	+/-0.010	.335	✓			
0.13	+/-0.030	.126	✓			
R0.06	+/-0.030	R.06	✓		R.G	
1.31	+/-0.030	1.308	✓			

Measured by:	SJ
Date:	12/6/24

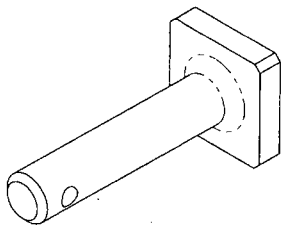
Audited by:	mf
Date:	12/06/24

Prototype Approval:	N/A
Date:	N/A

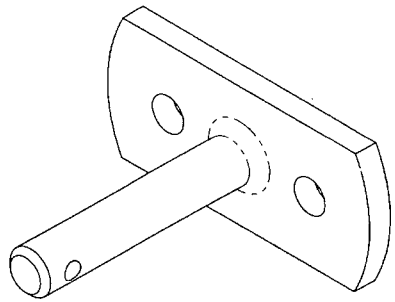
Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	
B	09.12.14	Dwg Rev updated	KJ	



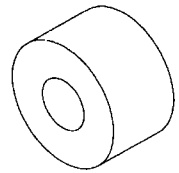
D3953-1 GAS SPRING BRACKET
(FULL LID)



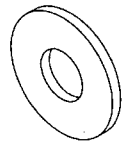
D3953-3 GAS SPRING STUD, LID



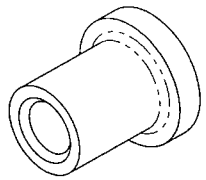
D3953-5 GAS SPRING STUD, BASE



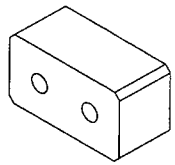
D3953-7 GAS SPRING SPACER



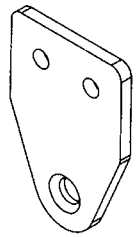
D3953-9 GAS SPRING WASHER



D3953-11 GAS SPRING SPACER



D3953-13 GAS SPRING SPACER
(FULL LID)



D3953-15 GAS SPRING BRACKET
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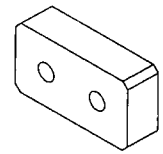
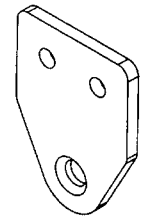


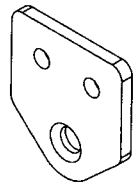
D3953-17 GAS SPRING SPACER
(SPLIT LID)



D3953-19 GAS SPRING BRACKET
(SQUARE BASKET)
△C

RELEASED
2010-02-26

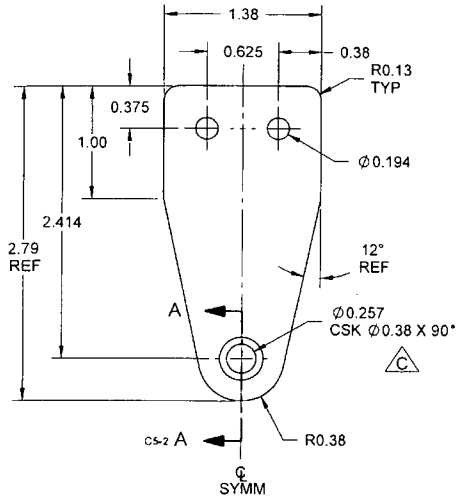
SHOP C[illegible]
RETURN[illegible]
ENGINEERING
UNCONTROLLED C[illegible]
SUBJECT TO AMENDME[illegible]
WITHOUT NOTICE
WORK ORDER
NO. 85788 MLJ
12/06/15



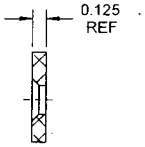
D3953-21 GAS SPRING BRACKET
(SQUARE BASKET)
△C

REV.	DESCRIPTION	BY	DATE
C	PARTS -19 & -21 ADDED (SHT 1& 4); CSK CALLOUT WAS CHAM (C6-2, B6-3, C6-4); ℄ SYMM WAS ℄ SYM ABOUT (C7-2, C7-4); SECTION C-C REPOSITIONED TO B2-4 REASON: ADDL PARTS REQD; DRAFTING ERRORS	JPH	10.01.29
B	SHEET 3 ZONE C1, DIM 0.05 MIN WAS 0.13, MULTIPLE DIMENSIONS MIN/MAX REMOVED TOLERANCE ADDED. REASON: DIFFICULTY INSTALLING COTTER PIN AT NEXT ASSY.	AJS	09.11.11
A	NEW ISSUE	AJS	09.07.27

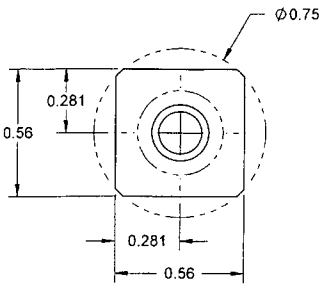
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	[illegible]	DRAWING NO. D3953	REV. C
MFG. APPR.	[illegible]		SHEET 1 OF 4
APPROVED	[illegible]	TITLE	SCALE
DE APPR.	[illegible]	GAS SPRING LID COMPONENTS	NTS
DATE	10.01.29		

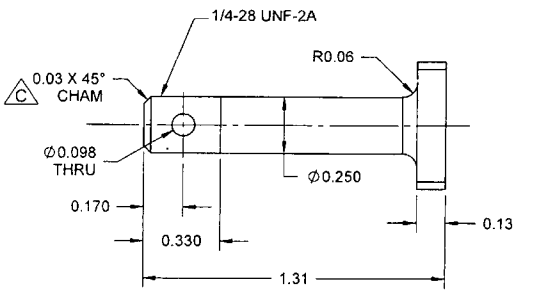


D3953-1 GAS SPRING BRACKET
(FULL LID)

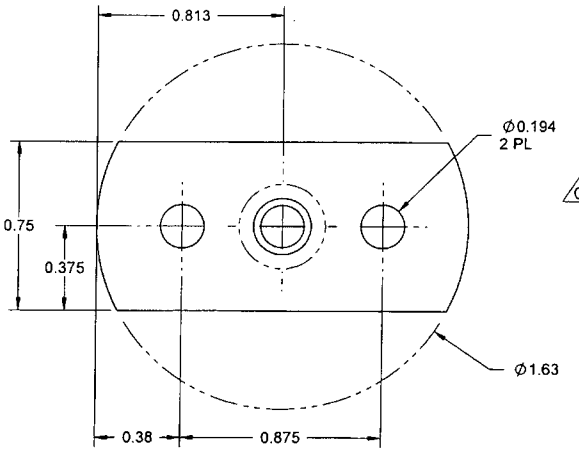


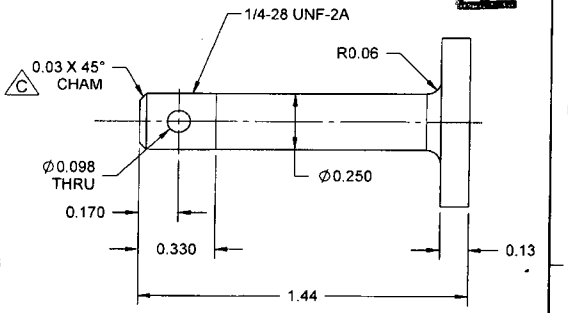
SECTION A-A C7-2





D3953-3 GAS SPRING STUD, LID





D3953-5 GAS SPRING STUD, BASE

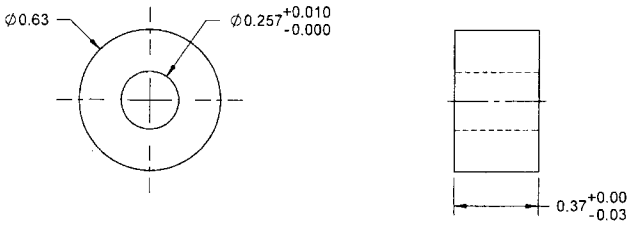
RELEASED
2010-02-26

NOTES:
1) MATERIAL -1: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA

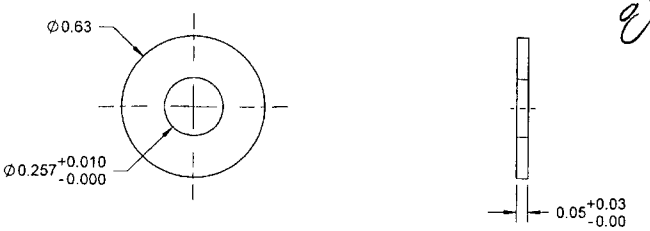
-3 & -5: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B
OR:
AISI 304/316 STAINLESS STEEL ROD
REF DART SPEC M304R

2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3953-X" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT -1: 0.11 lbs
-3: 0.03 lbs
-5: 0.06 lbs

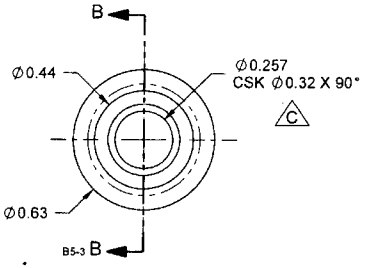
DESIGN	AJS	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	JPH	
CHECKED		DRAWING NO. D3953 REV. C
MFG. APPR.		SHEET 2 OF 4
APPROVED		TITLE GAS SPRING LID COMPONENTS SCALE NTS
DE APPR.		
DATE	10.01.29	



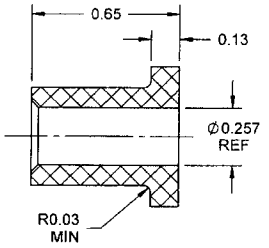
D3953-7 GAS SPRING SPACER



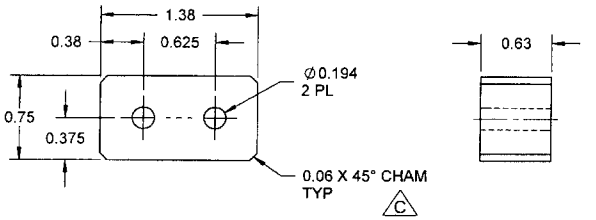
D3953-9 GAS SPRING WASHER



D3953-11 GAS SPRING SPACER



SECTION B-B B7-3



D3953-13 GAS SPRING SPACER

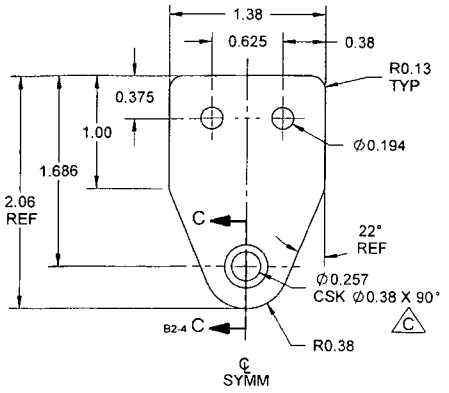
RELEASED
2010 -02- 26

NOTES:
1) MATERIAL -7,-9 & -11: DELRIN II 150E OR ACETRON GP ACETAL, BLACK
REF DART SPEC M-DELRIN-R

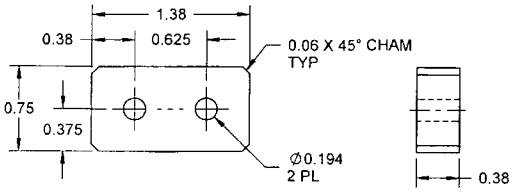
-13: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B

2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION -13 ONLY: IDENTIFY WITH DART P/N "D3953-13" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT -7/-9/-11: < 0.01 lbs EACH
-13: 0.17 lbs

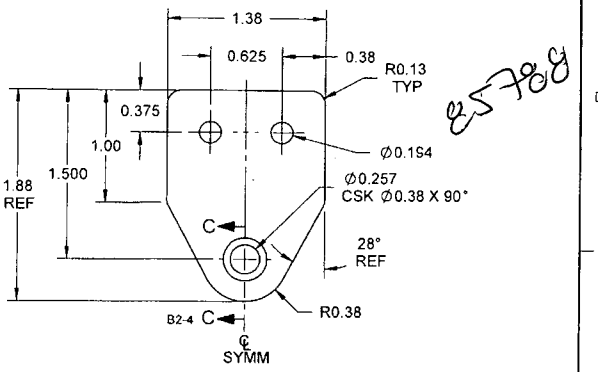
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3953	REV.: C
MFG. APPR.			SHEET 3 OF 4
APPROVED		TITLE GAS SPRING LID COMPONENTS	SCALE NTS
DE APPR.			
DATE 10.01.29			



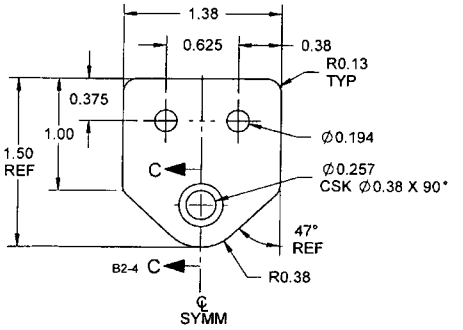
D3953-15 GAS SPRING BRACKET
(SPLIT LID)



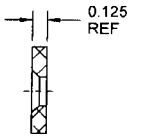
D3953-17 GAS SPRING SPACER
(SPLIT LID)



D3953-19 GAS SPRING BRACKET
(SQUARE BASKET)
C



D3953-21 GAS SPRING BRACKET
(SQUARE BASKET)
C



SECTION C-C C7-4 C2-4 B4-4
C

RELEASED
2010 -02- 26

NOTES:
1) MATERIAL -15/-19/-21: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA

-17: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B

2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3953-X" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT -15: 0.08 lbs
-17: 0.10 lbs
-19: 0.07 lbs
-21: 0.06 lbs
C

DESIGN	AJS	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	JPH	DRAWING NO. D3953 REV. C
CHECKED		SHEET 4 OF 4
MFG. APPR.		TITLE GAS SPRING LID COMPONENTS SCALE NTS
APPROVED		
DE APPR.		
DATE	10.01.29	